

Work Order ID 65921-3

Thursday, January 27, 2011 10:47:15 AM



Page 1

Item ID: D3916-041

Revision ID:

Item Name: Rib Assembly

Start Date: 1/27/2011 Start Qty: 6.00

Required Date: 2/4/2011 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date: 11-01-27 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3916

A

100

Weld per dwg A/R S.S. rod Batch: 115928 0.00

Large Fab

Memo

0.00

Large Fab

1- Cut tube 50"
2- Bend tube with manuel pipe bender as per DT9567
*** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
3- Trim access tube material to finish size as per dwg D3916
4- Drill and chamfer holes as per dwg D3916-1 using DT9605
5- weld bushing as per dwg D3916
6- grind welds flush

110

QC5- Inspect part completeness to step on W/O 0.00

QC

Memo

0.00

Quality Control

8-10-01

14

SAN 11-02-03

11-03-01

1107

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/02/17	100	Found After welding D3759-1 Bushings that the D3716-01 Rib wasn't been enough when put against DT 9567 the Rib shows it wasn't bent enough in the Load Bero. P.C. high at Attention when bending Rib - but check correctly to DT 9567)						

NOTE: Date & initial all entries

Work Order ID 65921

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Item ID: D3916-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 1/27/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8 x 103/01

(+7)

130



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

dy 11-03-01 (7x)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/03/03 J
mf
11-03-03

Picklist Print

Thursday, January 27, 2011 10:47:28 AM

Page 1

Work Order ID: 65921

Parent Item: D3916-041

Parent Item Name: Rib Assembly



Start Date: 1/27/2011

Required Date: 2/4/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3759-1 Manufactured No

100 Each 9.0000



Bushing

Location

Loc Qty

Loc Code

WA

9

54072

9

M304TS0.750W.049

Purchased

No

100 f 92.0831



304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT

55.13726794

113763

0

114323

8.15031894

114677

0.00001

114835

0.000039

116319

25.1993

116509

21.7876

MAT017

3.68448E-05

114298

3.6845E-05

WA

36.9458

114992

11.0693

115260

25.8765

7 42 60489 (39) 11-03-01
~~366125~~
~~365924~~
~~365906~~ (10)
~~366489~~ (10)
 26.31158 61.3938
 SAO 11-03-01

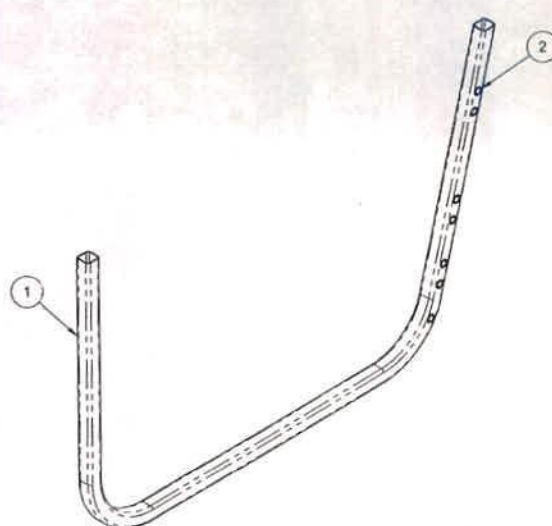
71116719

END BAR
Scrap

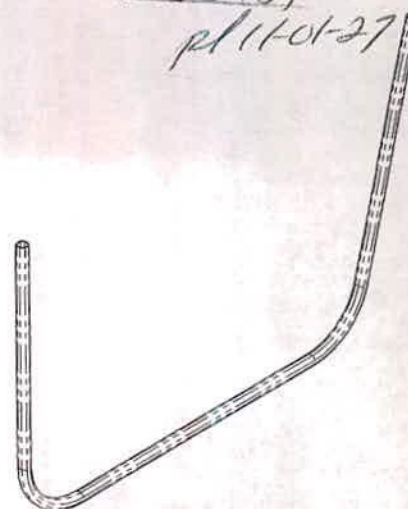
61.3938
3.000
64.3938

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 015921
pl 11-01-27



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

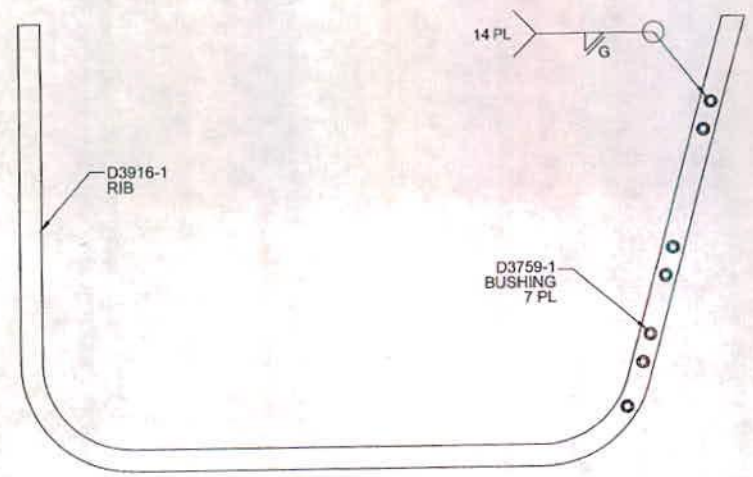
OK 10.12.21
~~UNDER REVIEW~~
~~10.10.11~~
ADDITIONAL HOLE + BUSHING
ON D3916-041-1 RIBS.

RELEASED
2010-03-12
JPH

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.03.04		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D3916**
REV. A
SHEET 1 OF 4
TITLE **RIB ASSY, 350 BASKET**
SCALE
NTS
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W1065921



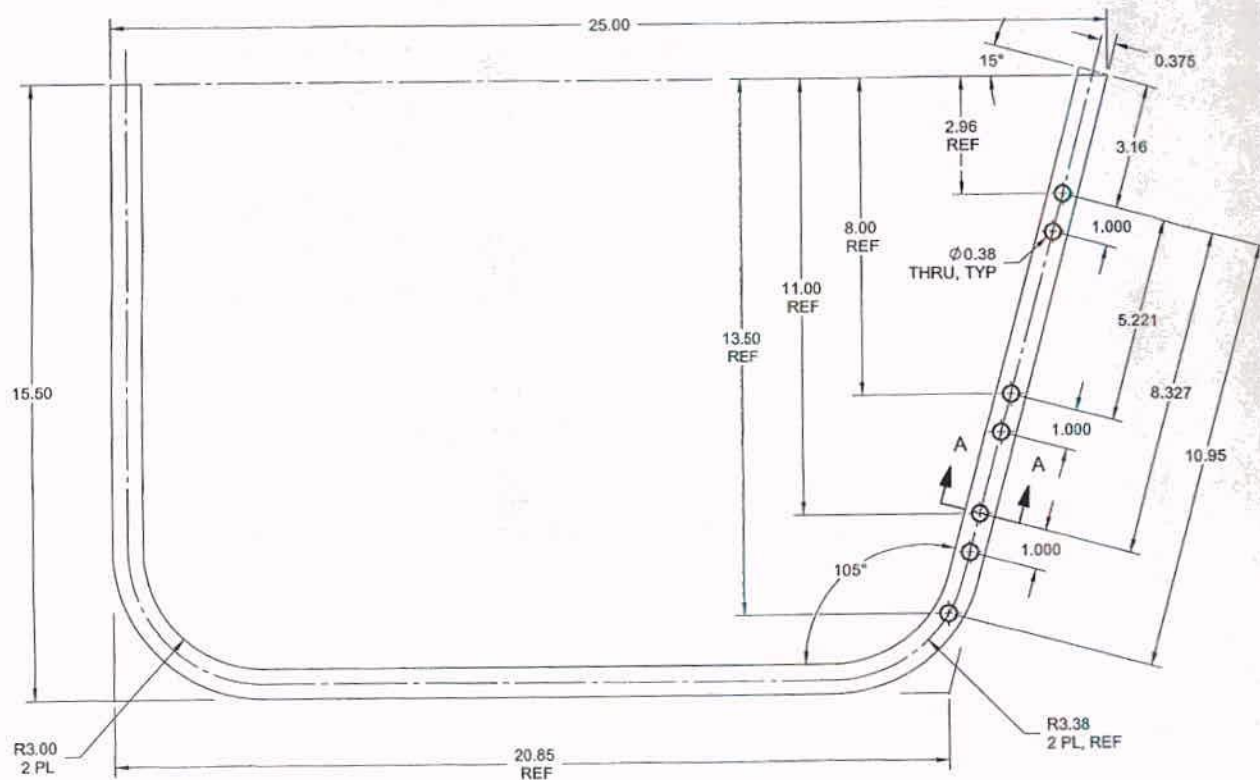
D3916-041 RIB ASSY

RELEASED
2010-03-12
MP

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT -041: 1.84 lbs
 - 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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u/o 65921



SECTION A-A

9 D3916-1 RIB

RELEASED
2010-03-12
NMP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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